

Friday, 09/05/2008 1:50:38 PM  
Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	DOOR ASSEMBLY
<b>Job Number</b> :	39169B		
<b>Estimate Number</b> :	12356		
<b>P.O. Number</b> :		<b>Part Number</b> :	D41269402
<b>This Issue</b> :	09/05/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D412-694
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	36652B	<b>Drawing Revision</b> :	C1
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	JUD 08.5.09	<b>Due Date</b> :	15/06/2008
<b>Comment</b> :	Est Rev: A 05.12.09 New Issue	<b>Qty:</b>	1 Um: Each
	Est Rev: B 06.04.18 New dwg rev. ecn781		
	Est Rev: C 06.07.10 Revised per B24659		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Issue red decal labels for D412-694-02. CHG005

2.0	COMPOSITE ASSY	COMPOSITE ASSEMBLY
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**Comment:** COMPOSITE ASSEMBLY

D412-694-02 Drill Process

1- D412-694-02 Drill Process Drill (7) holes using Ø(#40) drill. Drill (3) holes top/bottom Ø(#40) for insert (do not pass thru) using B30-23000-02 as per Dwg D412-694 page 4 (view P). *080626*

2- Open (1) hole to 11/16" (0.688) for the handle using unibit. Transfer (4) Ø(#30) holes from D3151-041 to the door and c'sink from far side for the rivet. Transfer (2) holes Ø(3/16") for MS24694-C5 screw as per Dwg D412-694 page 4 (view P). Note: D3151-041 orientation in the door. *080626*

3- Open (3) holes Ø(#19) or (0.166) top/bottom of the door and c'sink Ø0.300 x 100° from the far side and D3155-041/-042 bracket assembly as per Dwg D412-694 page 4 (view P). *080626*

4- Drill Ø(#30) holes using drill Jig D3144-T7 for the doublers. Drill (2) holes in two places Ø 3/16" (0.188) for the slot opening. Router slot using D3144-T8/-T9 as per Dwg D412-694 page 2.  
Note: The (12) holes for the (6) nut plates cannot be less than 0.290" from inside edge. *080626*

5- Use unibit to open (3) holes to Ø37/64" (0.578) at top/bottom insert for D3163-042 cover assembly as per Dwg D412-694 page 4 (view P).  
Drill Ø(#30) outer door handle as shown in view Z-Z page 2. Open holes to Ø0.257. *080626*

6- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-7. Use unibit to open holes to Ø 37/64" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view K, L, M, Q). *080626*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DOOR ASSEMBLY

Job Number: 39169B

Part Number: D41269402

Job Number:



Seq. #:

Machine Or Operation:

Description :

7- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-2. Use unibit to open holes to Ø 37/64" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view H, J). *AS* 080626

8- Drill (27) pilot holes Ø(#30) using drill Jig DT8703-9 RH for D3126 brackets as per Dwg D412-694 page 2 (view G-G). Use unibit to open holes Ø37/64" (0.578) for inserts. *AS* 080626

9- Drill (2) Pilot holes Ø(#30) by transfer from D3152-042 bracket. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 6 (view Q). *AS* 080627

10- Drill (12) Ø(#30) holes from the edge of the door to opposite side for D3162-041 bracket using a long drill and keep drill perpendicular. Ensure (4) holes used from the center of the hole to top and bottom edge of the thick section of D3163-041 cover assembly. Compare hole depth with rivet in the foam as per Dwg D412-694 page 4 (view P) and (view R-R/-S-S). Drill (8) Ø(#30) holes from the edge of the door using a long drill and keep drill perpendicular. About the (4) last holes around the small square of the cover, take the measurement 0.250" from each corner of the D3163-042 cover. *AS* 080626

3.0

QC5

INSPECT WORK TO CURRENT STEP



*NIA*

*0807-07* *1*



*PC*

Comment: INSPECT WORK TO CURRENT STEP

4.0

8000528

Insert



Comment: Qty.: 55.0000 Each(s)/Unit Total: 55.0000 Each(s)

Insert

Batch

A/R Hysol EA934NA

Expiry Date:

*M19443*

*M107908*

*090320*

*AS*

*080626*

5.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1- Install inserts as per Dwg D412-694 page 2 (view G-G); page 6 (view H, J, L, M, Q).

2- Sand flush excess Hysol around the insert on both doors. *AS* 080626

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect that inserts are flush with the surface. *080716* *1*

Dart Aerospace Ltd

WIO: 39169 B		Est #: 12356 WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
080707	3.0	QCS not necessary in this location. Remove. Perm. change	ESIMAR 12356				080707	
080721	8.0	QC 14 is required. Perm change					080721	

Part No: D412-694-02 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169B

Part Number: D41269402

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1. Apply Primer filler and reducer around the inserts on both doors.

A/R 11045

Primer Filler

Batch:

108 307 / 106803

A/R 12375S

Reducer

Batch:

105 936

25 06 07 10

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

D31105

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Handle

Batch

B27081

AS

08/05/12

(X)

10.0

D31151

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket

Batch

B36152

AS

08/05/12

(X)

11.0

D31167

Seal



Comment: Qty.: 5.6666 f(s)/Unit Total: 5.6666 f(s)

Seal ZX2054

Batch

B27239

AS

08/05/12

(X)

12.0

D31169

Seal



Comment: Qty.: 6.4166 f(s)/Unit Total: 6.4166 f(s)

Seal ZX1267

Batch

B17463

AS

08/05/12

(X)

13.0

D3121041

Bracket Assembly



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Bracket Assembly

Batch

39183

AS

080724

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 39169B

Part Number: D41269402

Job Number:



Seq. #: Machine Or Operation: Description :

14.0 D3121044 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket Assembly

Batch

24699

JS 08/05/12

(XU)

15.0 D31221 Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Lever

Batch

M10536-17

\*this is the Marked Batch or it in Comp

JS 08/05/12

(XU)

16.0 D31231 Cam



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Cam

Batch

M10536-17

JS 08/05/12

(XU)

17.0 D31241 Hook



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Hook

Batch

M10536-17

JS 08/05/12

(XU)

18.0 D31242 Hook



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Hook

Batch

M10536-17

JS 08/05/12

(XU)

19.0 D31261 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket

Batch

30128

JS 08/05/12

(XU)

20.0 D31263 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket

Batch

B18657

JS 08/05/12

(XU)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: DOOR ASSEMBLY

Job Number: 39169B

Part Number: D41269402

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D31265

Bracket



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bracket

Batch

36729

AS 08/08/25 (X1)

22.0

D3132042

Rod Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Rod Weldment

Batch

10536-17

AS 08/05/12 (X4)

23.0

D3133041

Rod Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Rod Weldment

Batch

M10536-17

AS 08/05/12 (X4)

24.0

D3135041

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Handle Weldment

Batch

36730

AS 08/05/12 (X4)

25.0

D3137045

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BRACKET ASSEMBLY

Batch

B27339

BATCH NOT IN CAMP. THIS IS WHAT'S MARKED ON IT.

AS 08/05/12 (X1)

26.0

D31382

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cover

Batch

24341

AS 08/05/12 (X1)

27.0

D31391

Guard



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Guard

Batch

B18863

Wrong Batch in camp.

AS 08/05/12 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 39169B

Part Number: D41269402

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D31394

Guard



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Guard

Batch

24751

AS 08/05/12 (X)

29.0

D314006

Door



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Door Kit

Batch

39169 B

AS 080724

30.0

D31411

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Spring #204-032-734-001

Batch

34725

AS 08/05/12 (X)

31.0

D314413

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Doubler

Batch

24723

AS 08/05/12 (X)

32.0

D3144111

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Doubler

Batch

27380

AS 08/05/12 (X)

33.0

D3144115

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Doubler

Batch

~~35578~~ 22021

AS 08/05/12 (X)

34.0

D3144123

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Doubler

Batch

22025

AS 08/05/12 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Process Sheet

0

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169B

Part Number: D41269402

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D31481

Clevis



PTC

Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Clevis

Batch

10536-17

AS

08/05/12

XC

36.0

D3151041

Doubler Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Doubler Assembly

Batch

39186

AS

080724

37.0

D3152042

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket Assembly

Batch

25285

AS

08/05/12

XC

38.0

D3155041

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket Assembly

Batch

27178

AS

08/05/12

XC

39.0

D3155042

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket Assembly

Batch

26933

AS

08/05/12

XC

40.0

D31561

Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bracket

Batch

24772

AS

08/05/12

XC

41.0

D3162041

Bracket Assembly



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bracket Assembly

Batch

27155

AS

08/05/12


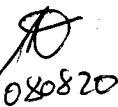
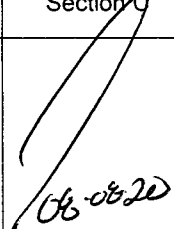
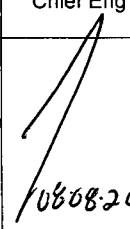
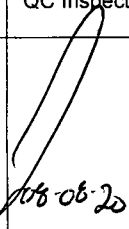
XC

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-694-02 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>39169B</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
080820	35.0	1x D314B-1 M10536-17 was found to be ground into the material. R.C.: unknown.		Scrap, destroy & replace Qty 1. Picked M10536-17				

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Job Number: 39169B

Part Number: D41269402

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

D3162043

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket Assembly

Batch

36949

AS 08/05/12 (XU)

43.0

D3162044

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket Assembly

Batch

36734

AS 08/05/12 (XU)

44.0

D3163042

Cover Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cover Assembly

Batch

27837

AS 08/05/12 (XU) PTO

45.0

D3183042

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket Assembly

Batch

36736

AS 08/05/12 (XU)

46.0

D32031

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Handle

Batch

29382A

AS 08/05/12 (XU)

47.0

D33081

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Doubler

Batch

39187

AS 080724

48.0

AN52510R6

Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Screw

Batch

M15943

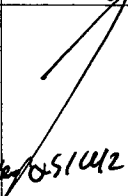

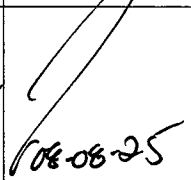
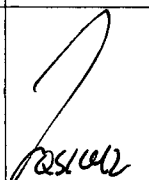
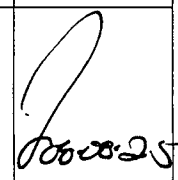
AS 08/05/12 (XU)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-694-02 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>39169 B</u>		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-08-25	44.0	1x D363-042 B27837 is scump. Part was riveted opposite to drawing. R.C. parts were one upon a time re-worked to apply sika-tite and new rivets.		Scump: des tral : Replace qty 1 B <u>27837</u>	 080825	 08-08-25	 08/08/25	 080825

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Job Number:



Seq. #:

Machine Or Operation:

Description :

49.0

AN52510R7

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

Batch

M106166

AS 08/05/12

(XL)

50.0

AN960JD8

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch

M107091

AS 08/05/12

(XL)

51.0

AN960JD10L

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch

M104885

AS 08/05/12

(XL)

52.0

AN960JD10LL

Washer



Comment: Qty.: 15.0000 Each(s)/Unit Total : 15.0000 Each(s)

Washer

Batch

M19600

AS 08/05/12

(XL)

53.0

AN960JD416L

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch

M167008

AS 08/05/12

(XL)

54.0

BSP45

Commercial Rivet



Comment: Qty.: 79.0000 Each(s)/Unit Total : 79.0000 Each(s)

Commercial Rivet

Batch

M106937 x19 M167290 x160

AS 08/05/12

(XL)

55.0

BSP46

Commercial rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Commercial rivet

Batch

M161237

AS 08/05/12

(XL)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:50:38 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169B

Part Number: D41269402

Job Number:



Seq. #:

Machine Or Operation:

Description :

56.0

M7885243

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Rivet

Batch

M107376

AS 08/05/12 (XU)

57.0

M7885344

Rivets



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Rivets

Batch

19099

AS 08/05/12 (XU)

58.0

MS203922C9

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pin

Batch

11784

AS 08/05/12 (XU)

59.0

MS203922C17

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pin

Batch

M18949

AS 08/05/12 (XU)

60.0

MS203923C21

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pin

Batch

104156

AS 08/05/12 (XU)

61.0

MS20426AD33

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Rivet

Batch

M1563

AS 08/05/12 (XU)

62.0

MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Rivet

Batch

M3459

AS 08/05/12 (XU)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:50:38 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169B

Part Number: D41269402

Job Number:



Seq. #:

Machine Or Operation:

Description :

63.0

MS20426AD46

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

Batch

M105744

AS 08/05/12 (XU)

64.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch

M66051

AS 08/05/12 (XU)

65.0

MS21042L08

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch

M107423

AS 08/05/12 (XU)

66.0

MS21072L3

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nutplate

Batch

M107003

AS 08/05/12 (XU)

67.0

MS24665151

Cotter Pin



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Cotter Pin

Batch

14526

AS 08/05/12 (XU)

68.0

MS24693S271

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

M14478

AS 08/05/12 (XU)

69.0

MS24694C5

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

M106815

AS 08/05/12 (XU)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:50:38 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169B

Part Number: D41269402

Job Number:



Seq. #:

Machine Or Operation:

Description :

70.0

MS24694S5

Screw



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Screw

Batch

M18949

AS 08/05/12

(X)

71.0

MS24694S50

Screw



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Screw

Batch

M107393

AS 08/05/12

(X)

72.0

MS24694S98

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

M107534

AS 08/05/12

(X)

73.0

MS27039105

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch

M3501

AS 08/05/12

(X)

74.0

MS27039106

Screw



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Screw

Batch

M106815

AS 08/05/12

(X)

75.0

MS27039108

Screw



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Screw

Batch

M10589

AS 08/05/12

(X)

76.0

MS35275233

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch

M11822

AS 08/05/12

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Friday, 09/05/2008 1:50:38 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169B

Part Number: D41269402

Job Number:



Seq. #:

Machine Or Operation:

Description :

77.0

MS35649264

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch

11822

AS 08/05/12 (XU)

78.0

MS356503252

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch

11735

AS 08/05/12 (XU)

79.0

MS518597

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

Batch

10621

AS 08/05/12 (XU)

80.0

NAS43DD310

Spacer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Spacer

Batch

19347

AS 08/05/12 (XU)

81.0

NAS43DD314

Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Spacer

Batch

19347

AS 08/05/12 (XU)

82.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-02 Assembly Process

1- Install D3162-041 as per Dwg D412-694 page 4 (view R-R/S-S) and D3156-1 bracket as per (view T-T/U-U). Open holes to #30 (0.128) for rivet and alodine the open holes.  
Note: Start installation window side. Wait to fix D3162-043/-044.

2- Install D3151-041 Doubler as per Dwg D412-694 page 4 (view P).

3- Connect D3132-042 Rod Weldment with D3122-1 Lever and D3133-042 Rod Weldment as per Dwg D412-694 page 4 (view P).

AS 080819

AS 080819

AS 080819

(PU)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-694-02 PAR #: N/A Fault Category: Prod Support NCR: Yes No DQA: D Date: 08/08/20  
 QA: N/C Closed: D Date: 08/08/20

NCR: <u>39169B</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08-08-20</u>	<u>020</u>	<u>1x D 3162-043 was installed (transfer drilled) too low into the door. R.C: Human error on location</u>	<u>[Signature]</u> <u>08/08/20</u>	<u>Scrap &amp; replace Qty 1 B36949</u>	<u>[Signature]</u> <u>08/08/20</u>	<u>[Signature]</u> <u>08-08-20</u>	<u>[Signature]</u> <u>08/08/20</u>	<u>[Signature]</u> <u>08-08-20</u>
	<u>8</u>							

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:50:38 PM  
User: Julie Lecocq

## Process Sheet

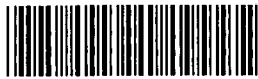
Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169B

Part Number: D41269402

Job Number:



Seq. #:

Machine Or Operation:

Description :

4- Assemble D3123-1 Cam with D3124-1/-2 Hook with D3155-041/-042 Bracket Assembly as per Dwg D412-694 page 4 (view P).

080819

5- Install D3203-1 handle with D3308-1 doubler as per Dwg D412-694 page 2 (view Z-Z).

080819

6- Install D3155-041/-042 Bracket Assembly and D3110-5 Handle as per Dwg D412-694 page 4 (view P) and page 2. Adjust rod weldment until everything works properly and looks in place.

080819

83.0

QC5

INSPECT WORK TO CURRENT STEP



080820 (1)



Comment: INSPECT WORK TO CURRENT STEP

84.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-02 Assembly Process (Continued)

1- Install D3116-7-0680 Seal and doublers. Transfer slot opening in the seal as per Dwg D412-694 page 2 (view V-V and N).

Note: If this is the D412-694-013, wait until the VIP trim is fixed on the door.

080821

2- Install D3110-5 Handle Assembly in the D3163-042 Cover Assembly. Ensure Handle works freely. Ensure D3163-042 cover assembly is aligned with the door edge on both sides and D3110-5 Handle works properly.

080821

3- Transfer the holes to the cover with the hole finder. EXCEPTION: the (4) holes around the handle. Install the bracket with the holes from the small square of the cover (Ø0.250")

080821

4- Open 15/64" (0.234) holes to D3163-042 cover assembly and D3135-041 handle weldment. Transfer D3139-1/-4 guard holes in cover assembly and drill holes for nutplate. Deburr and touch up holes with alodine as per Dwg D412-694 page 2.

080822

5- Install MS21072-L3 Nutplate and Guard as per Dwg D412-694 page 2.

080822

6- Transfer (#30) holes from D3144-13 doubler to seal and door. Ensure D3116-9-0770 is properly aligned as per Dwg D412-694 page 2 (section NN-NN). Apply 732 RTV Clear (A/R) in the hole prior to installing rivet and then in the rivet head after installation.

080821

A/R RTV732 Clear Batch: M/08657 Expiry: 09-07-17

080821

7- Install D3126 Brackets and D3138-2 Cover as per Dwg D412-694 page 2 (view G-G and NN-NN).

080822

8- Install and assemble brackets as per Dwg D412-694 page 2 and 5 (view H, J, L, M and Q).

080821

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:50:38 PM  
User: Julie.Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169B

Part Number: D41269402

Job Number:



Seq. #:

Machine Or Operation:

Description :

85.0

QC5

INSPECT WORK TO CURRENT STEP



*08.08.22*

Comment: INSPECT WORK TO CURRENT STEP

86.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

- 1- Finish installing D3163-042 in the door.
- 2- Install red decal before closing cover.

*08.08.22*  
*08.08.22*

87.0

QC5

INSPECT WORK TO CURRENT STEP



*08.08.25*

Comment: INSPECT WORK TO CURRENT STEP

Install door on mock up helicopter to insure proper fit and function.

88.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

*plp 39169*      *u 08.08.25*

89.0

QC21

FINAL INSPECTION/W/O RELEASE



*08/08/25*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*u 08.08.25*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
X				D412-694-01	DOOR ASSEMBLY
	X			D412-694-02	DOOR ASSEMBLY
		X		D412-694-03	DOOR ASSEMBLY
			X	D412-694-04	DOOR ASSEMBLY
		1	1	D3110-1	ESCUTCHEON
		1	1	D3110-3	HANDLE
1	1			D3110-5	HANDLE ASSEMBLY
		1	1	D3111-041	PLATE ASSEMBLY
		2	2	D3112-1	GUIDE
		1	1	D3113-1	SPRING
		1	1	D3114-1	PIVOT
1	1			D3115-1	BRACKET
		1	1	D3116-11-0180	SEAL
		1	1	D3116-5-0680	SEAL
1	1			D3116-7-0680	SEAL
1	1			D3116-9-0770	SEAL
		1		D3119-041	COVER ASSEMBLY
			1	D3119-042	COVER ASSEMBLY
		1		D3120-1	COVER
			1	D3120-2	COVER
		1		D3120-3	COVER
			1	D3120-4	COVER
3	3			D3121-041	BRACKET ASSEMBLY (ROLLER)
1				D3121-043	BRACKET ASSEMBLY (ROLLER)
		1		D3121-044	BRACKET ASSEMBLY (ROLLER)
1	1			D3122-1	LEVER
2	2			D3123-1	CAM
1	1			D3124-1	HOOK
1	1			D3124-2	HOOK
		1	1	D3125-1	LEVER
		1	1	D3125-3	LEVER
		1	1	D3125-5	LEVER
		1	1	D3125-7	LEVER
1	1			D3126-1	BRACKET (SLIDER)
1	1			D3126-3	BRACKET (SLIDER)
5	5			D3126-5	BRACKET (SLIDER)
1	1			D3127-1	SPACER
		1	1	D3128-1	SHIM
		2	2	D3129-1	LEVER
		2	2	D3130-1	CLEVIS BASE
		1	1	D3131-1	STOP
1				D3132-041	ROD WELDMENT
	1			D3132-042	ROD WELDMENT
	1			D3133-041	ROD WELDMENT
1				D3133-042	ROD WELDMENT
		1	1	D3134-1	ROD
		1	1	D3134-3	ROD
1	1			D3135-041	HANDLE WELDMENT
1	1			D3137-045	BRACKET ASSEMBLY
1				D3138-1	COVER
	1			D3138-2	COVER
1	1			D3139-1	GUARD
1				D3139-3	GUARD
	1			D3139-4	GUARD
1				D3140-05	DOOR
	1			D3140-06	DOOR
		1		D3140-07	DOOR
			1	D3140-08	DOOR
2	2			D3141-1	SPRING
		1	1	D3143-1	CLEVIS
		3	3	D3143-3	CLEVIS
		1		D3144-1	DOUBLER
1				D3144-3	DOUBLER
	1			D3144-105	DOUBLER
	1			D3144-107	DOUBLER
1				D3144-109	DOUBLER

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
1	1			D3144-111	DOUBLER
	1			D3144-115	DOUBLER
		1		D3144-117	DOUBLER
		1		D3144-121	DOUBLER
		1		D3144-119	DOUBLER
	1			D3144-123	DOUBLER
1	1			D3144-13	DOUBLER
		1		D3145-1	HINGE BRACKET
		1		D3145-2	HINGE BRACKET
		1		D3146-1	HINGE BRACKET
		1		D3146-2	HINGE BRACKET
		2	2	D3147-1	PIN
2	2			D3148-1	CLEVIS
		2	2	D3149-1	STRIKER PLATE
		2	2	D3150-1	GUIDE
1	1			D3151-041	DOUBLER ASSEMBLY
1				D3152-041	BRACKET ASSEMBLY
	1			D3152-042	BRACKET ASSEMBLY
		1	1	D3154-1	KEY
1	1			D3155-041	BRACKET ASSEMBLY
1	1			D3155-042	BRACKET ASSEMBLY
2	2			D3156-1	BRACKET
		2	2	D3157-1	SPACER
		3	3	D3159-041	BRACKET ASSEMBLY
		1		D3159-043	BRACKET ASSEMBLY
			1	D3159-044	BRACKET ASSEMBLY
10	10			D3162-041	BRACKET ASSEMBLY
1		1		D3162-043	BRACKET ASSEMBLY
1		1		D3162-044	BRACKET ASSEMBLY
1				D3163-041	COVER ASSEMBLY
	1			D3163-042	COVER ASSEMBLY
1				D3183-041	BRACKET ASSEMBLY (ROLLER)
	1			D3183-042	BRACKET ASSEMBLY (ROLLER)
1	1			D3203-1	HANDLE ASSEMBLY
2	2			D3308-1	DOUBLER
55	55	21	21	80-005-2-8	INSERT (OR SL2052-3-4)
10	10			AN625-10R6	SCREW
8	8	4	4	AN625-10R7	SCREW
		8	8	AN660-ID10	WASHER
18	18	4	4	AN660-ID10L	WASHER
13	13	32	32	AN660-ID10LL	WASHER
6	6			AN660-ID16L	WASHER
		4	4	AN660-ID6L	WASHER
6	6			AN660-ID8	WASHER
		2	2	AN660-ID8L	WASHER
		2	2	AN660-ID8LL	WASHER
		10	10	ASL4-632-80	INSERT
87	87	50	50	BSP45	RIVET
		12	12	FW10-032	WASHER
		6	6	FW4-032	WASHER
12	12			M7885-24	RIVET (OR CR3213-4-3)
		3	3	M7885-34	RIVET (OR CR3212-4-3)
		2	2	MS20392-1C11	PIN
		7	7	MS20392-2C15	PIN
2	2			MS20392-2C17	PIN
2	2	2	2	MS20392-2C9	PIN
2	2			MS20392-3C21	PIN
8	8			MS20426AD3	RIVET
12	12			M7885/3-4	RIVET
8	8			MS20426AD4	RIVET

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
20	20			MS20426AD4	RIVET
		6	6	MS21042L05	NUT
6	6	2	2	MS21042L08	NUT
		5	5	MS21042L3	NUT
4	4			MS21042L4	NUT
4	4			MS21072L3	NUT PLATE
6	6	9	9	MS24665-151	COTTER PIN
4	4			MS24683-S271	SCREW
		2	2	MS24694-C4	SCREW
4	4			MS24694-C5	SCREW
6	6			MS24694-S6	SCREW
18	18			MS24694-S60	SCREW
		4	4	MS24694-S66	SCREW
		2	2	MS24694-S63	SCREW
		4	4	MS24694-S80	SCREW
4	4			MS24694-S98	SCREW
		2	2	MS25281-R6	CLAMP
2	2	2	2	MS27039-1-05	SCREW
14	14	12	12	MS27039-1-06	SCREW
13	13	6	6	MS27039-1-08	SCREW
		2	2	MS35205-231	SCREW
2	2			MS35275-233	SCREW
2	2			MS36649-264	NUT
		4	4	MS36650-305T	NUT
2	2			MS36650-3252	NUT
2	2	3	3	MS51859-7	WASHER
		4	4	NAS1169-10L	WASHER
		14	14	NAS388-6-8P	SCREW
		15	15	NAS391B5P	WASHER
7	7			NAS430D3-10	SPACER
6	6			NAS430D3-14	SPACER
		2	2	NAS430D3-40	SPACER

# GENERAL NOTES:

- FOR ADJUSTMENT OF LOCKING MECHANISM PRIOR TO DOOR ASSEMBLY, SET AT UNLATCH POSITION AND ADJUST SCREW INWARD UNTIL D3124-1/2 HOOK RESTS AGAINST CUTOUT SHOWN IN VIEW N.
- IF REQUIRED, NOTCH D3125-1 LEVER (REF) TO CLEAR THE D3130-1 CLEVIS BASE (REF, 2 PLACES) TO ALLOW FOR FULL TRAVEL OF THE LEVER.
- HOLES AND PARTS TO BE LOCATED PER DRILLING JIGS, E30-23000-01; D3144-T1/T2-T3; D18703-3; D3162-041T1 (FOR -01 DOOR ASSY); E30-23000-02; D3144-T7/T8-T9; D18703-9; D3162-041T2 (FOR -02 DOOR ASSY); D3144-T4/T5-T6; D3119-041T1; D3112-T1/T2 (FOR -03 DOOR ASSY); D3144-T10/T11-T12; D3119-042T1; D3112-T1/T2 (FOR -04 DOOR ASSY).
- INSTALL INSERTS PER DART QSI 006. LOCATE TO MATCH HOLE PATTERN OF MATING PARTS.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- ALL DIMENSIONS ARE IN INCHES.
- IDENTIFY D412-694-01/-02/-03/-04 DOOR ASSEMBLIES USING D2729-1 DECALS.

CI	06.03.28	ADD OPTION M7885/3-4
C	05.11.23	ADD D3137-045; D3162-043/-044; REMOVE D3137-041; UPDATED NOTES
B	04.10.07	UPDATE DRAWING
A	02.05.21	NEW ISSUE
DESIGN	CP	DRAWN BY RF
CHECKED	#	APPROVED #
DATE	05.11.23	TITLE DOOR ASSEMBLY
		REV. C SHEET 1 OF 6
		SCALE NTS

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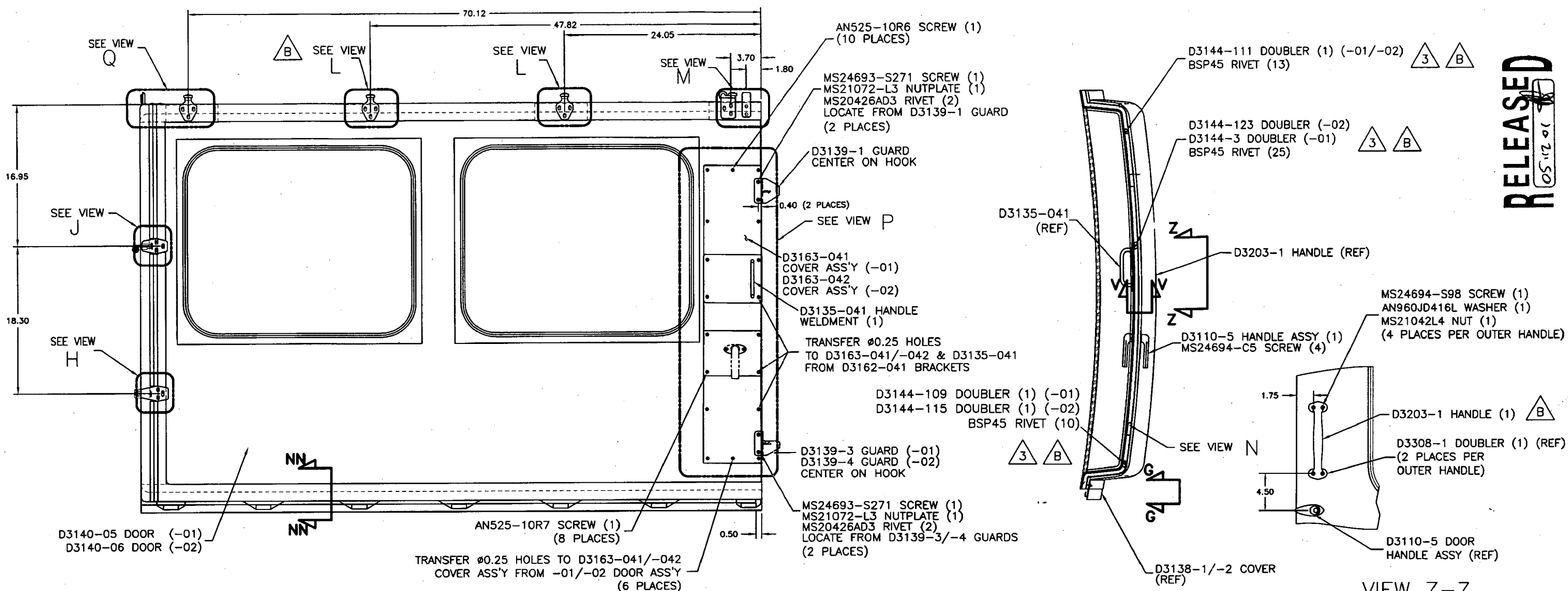
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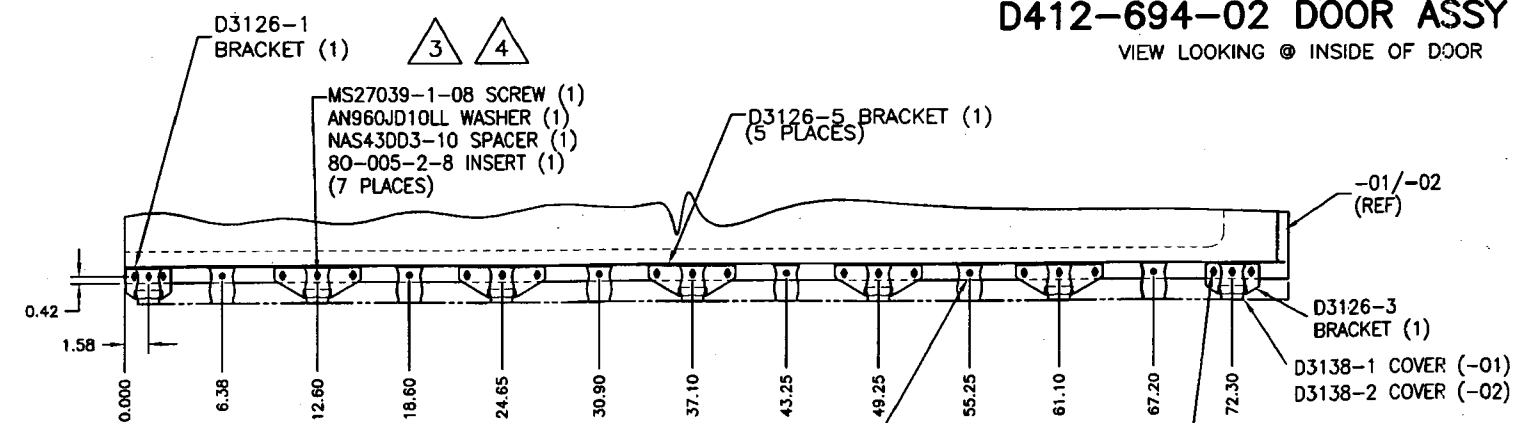
05.12.01-#

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05.11.23

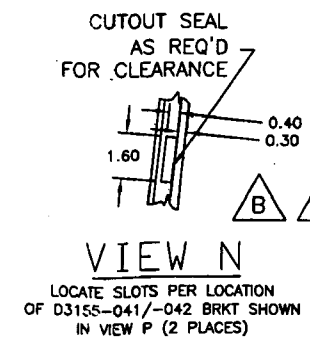
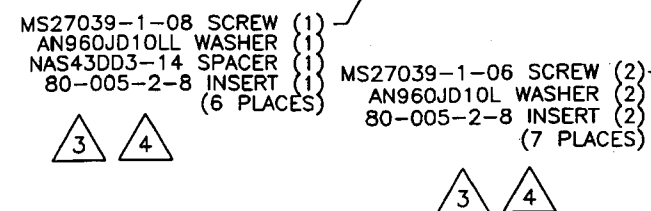


**D412-694-01 DOOR ASSY (SHOWN)**  
**D412-694-02 DOOR ASSY (OPP.)**  
 VIEW LOOKING @ INSIDE OF DOOR

**VIEW Z-Z**  
 OUTER DOOR HANDLE INSTALLATION



**VIEW G-G**  
 (D3138-1/-2 SHOWN IN SECTIONS FOR CLARITY OF HDWR LOCATIONS)

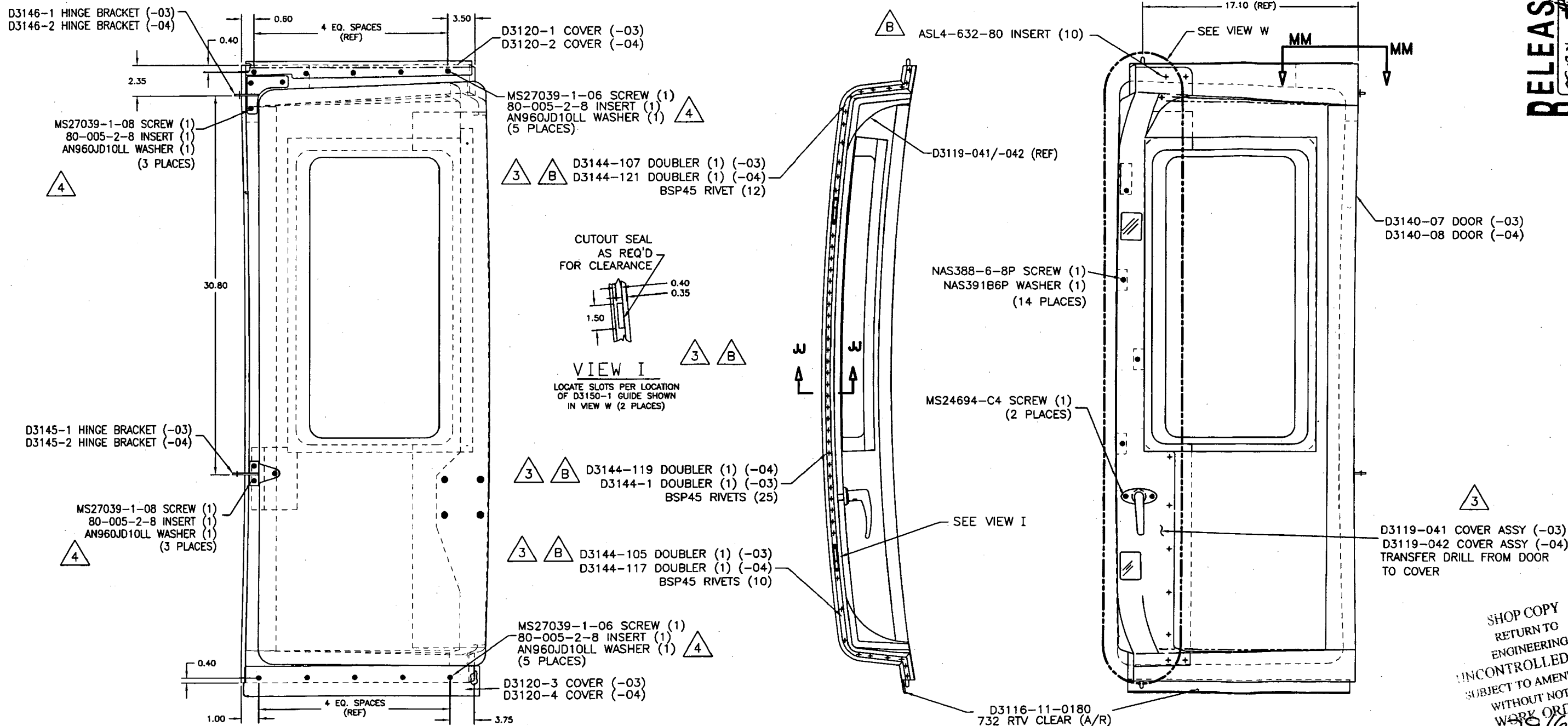


VIEW V-V  
 D3116-7-0680 SEAL (A/R)  
 D3144-3 DOUBLER (REF)  
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 WORK ORDER NO. 39162B

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CHECKED		DATE	APPROVED	DRAWING NO.	REV. C
05.11.23				D412-694	SHEET 2 OF 6
				TITLE	SCALE
				DOOR ASSEMBLY	NTS



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05-12-21



**D412-694-03 DOOR ASSY (SHOWN)**  
**D412-694-04 DOOR ASSY (OPP)**

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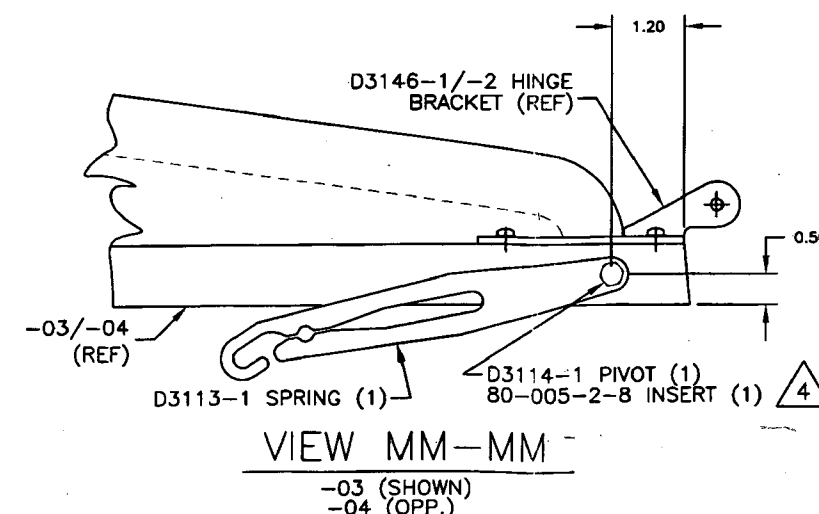
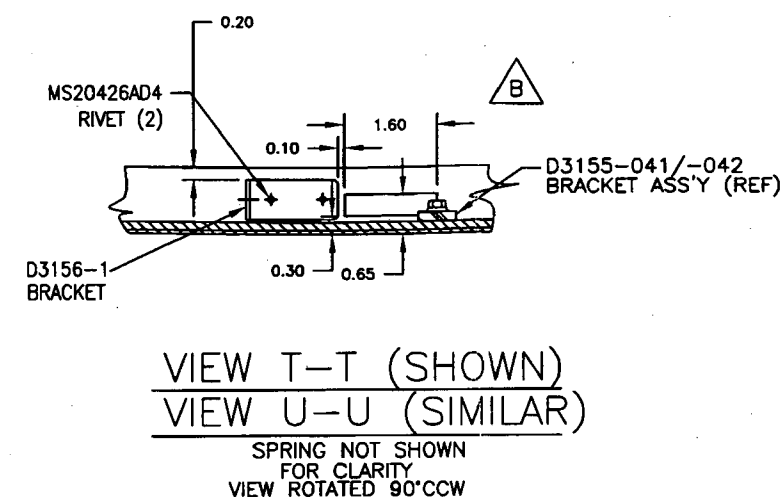
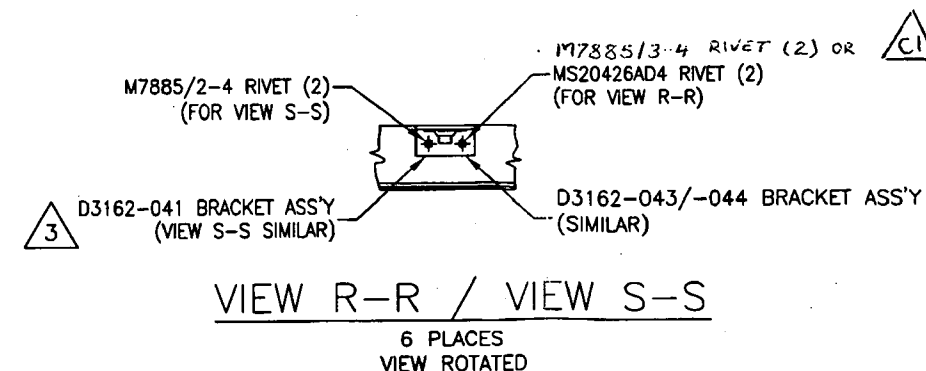
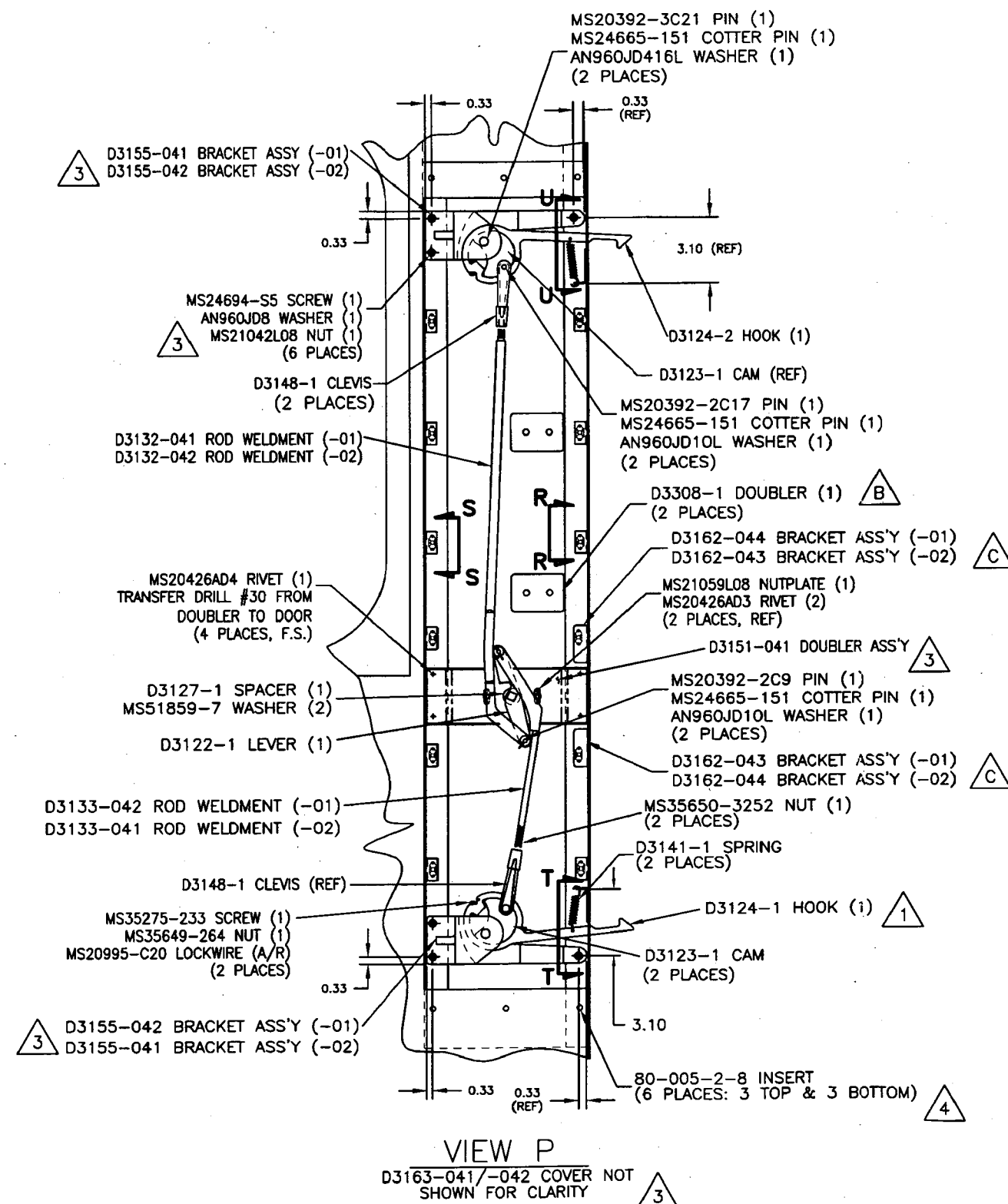
SECTION JJ-JJ

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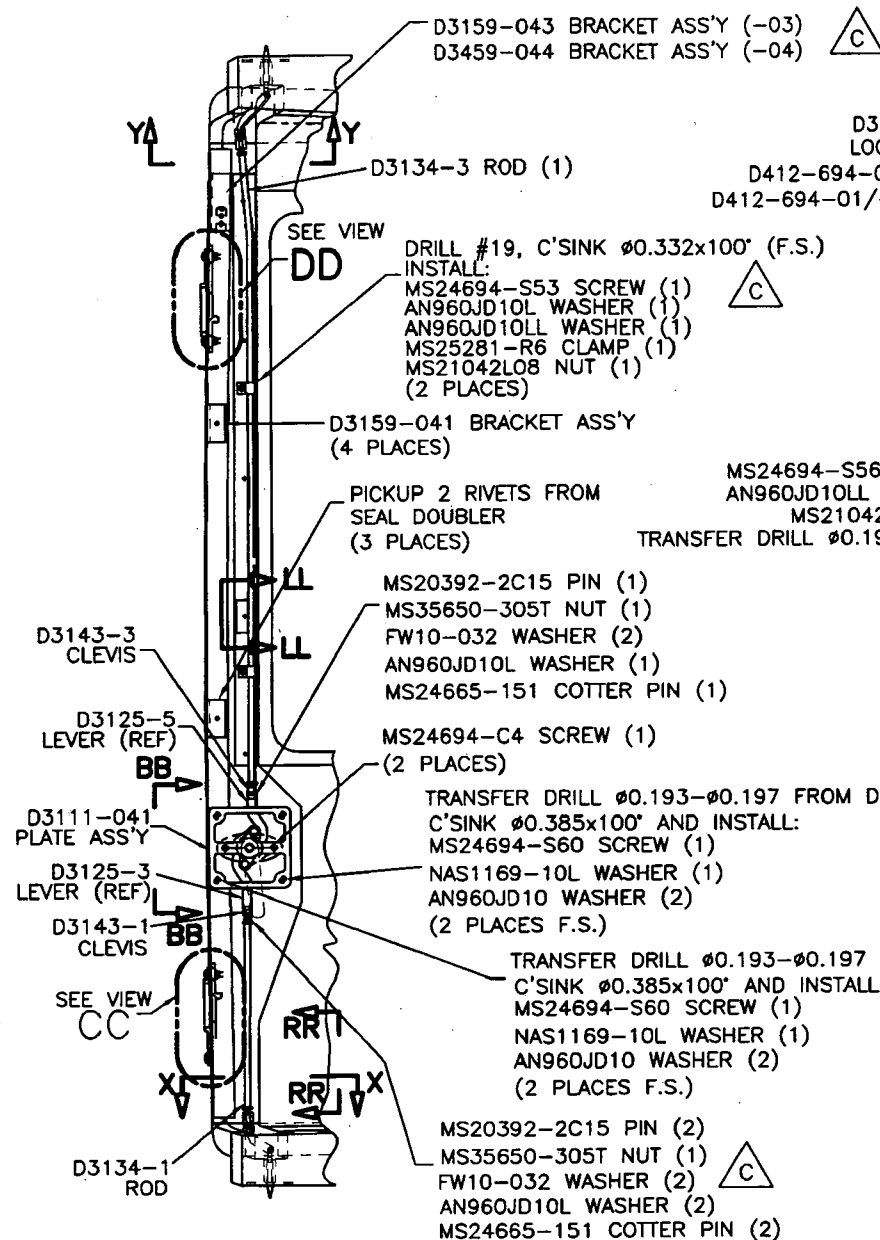
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DATE 05.11.23		TITLE DOOR ASSEMBLY	SHEET 3 OF 6 SCALE NTS

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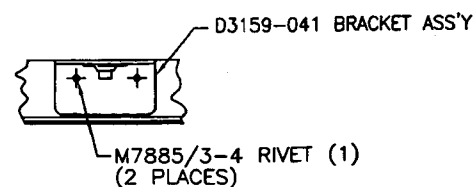
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DATE 05.11.23		TITLE DOOR ASSEMBLY		SCALE NTS	



VIEW W

D3119-041/-042 COVER ASS'Y NOT SHOWN FOR CLARITY  
SEAL ALSO NOT SHOWN FOR CLARITY



SECTION LL-LL  
(3 PLACES)  
VIEW ROTATED 90°CCW

D3150-1 GUIDE (1)  
LOCATE BY ALIGNING  
D412-694-03/-04 SLOTS IN  
D412-694-01/-02 CUTOUT A/R  
FOR CLEARANCE

D3128-1 SHIM  
(A/R)

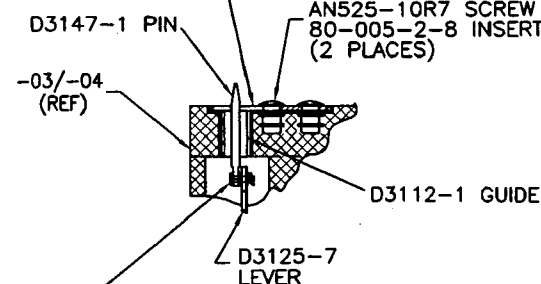
VIEW DD  
VIEW CC (SIMILAR)

MS24694-S56 SCREW (1)  
AN960JD10LL WASHER (1)  
MS21042L3 NUT (1)  
TRANSFER DRILL  $\phi 0.191$  TO DOOR  
(2 PLACES)

SEAL (REF)

D3149-1 STRIKER PLATE

RECESS DOOR FOR  
INSTALLATION OF  
D3112-1 GUIDE LEAVE  
0.040" AROUND D3112-1  
BRACKET TO ALLOW  
FOR ADJUSTMENT.  
FAIR IN FOAM USING  
HYSOL EA934 ADHESIVE



SECTION AA-AA

DRILL #10 ( $\phi 0.193$ )  
D3130-1 CLEVIS BASE (1)  
MS27039-1-06 SCREW (1)  
AN960JD10LL WASHER (1)

D3125-1 LEVER 0.80 (REF)

D3125-1 LEVER (TOP)  
D3125-7 LEVER (BOTTOM)

MS35650-305T NUT (1)

D3134-1/-3 ROD  
(REF)

D3143-3 CLEVIS

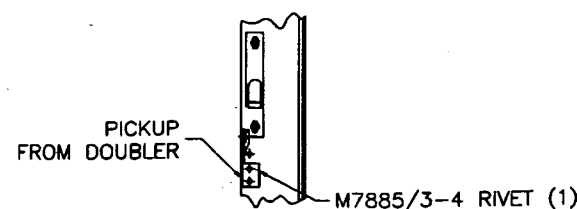
MS35206-231 SCREW (1)  
AN960JD6L WASHER (2)  
MS21042L06 NUT (1)  
(2 PLACES)

D3147-1 PIN (REF)  
MS20392-1C11 PIN (REF)

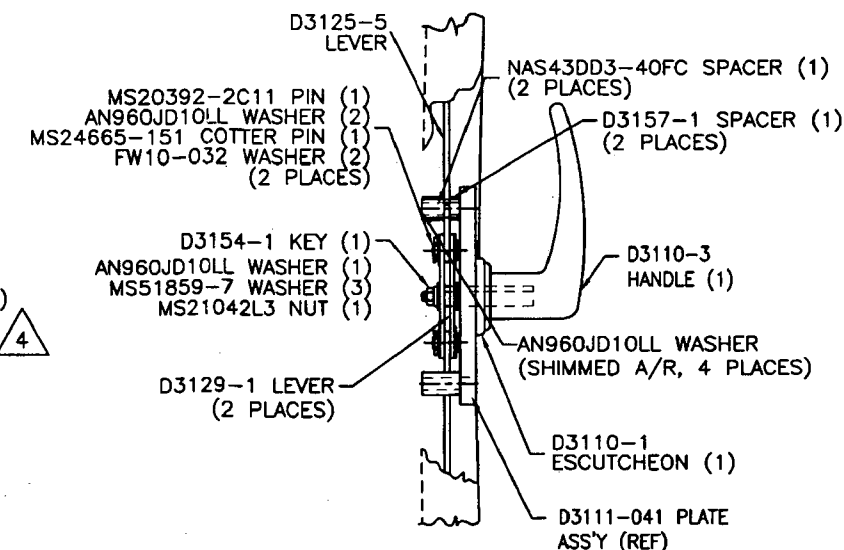
D3131-1 STOP  
MATCH DRILL D412-694-03/-04 (TOP ONLY)

MS20392-2C15 PIN (1)  
AN960JD10L WASHER (1)  
FW10-032 WASHER (2)  
MS24665-151 COTTER-PIN (1)  
(2 PLACES)

SECTION FF-FF

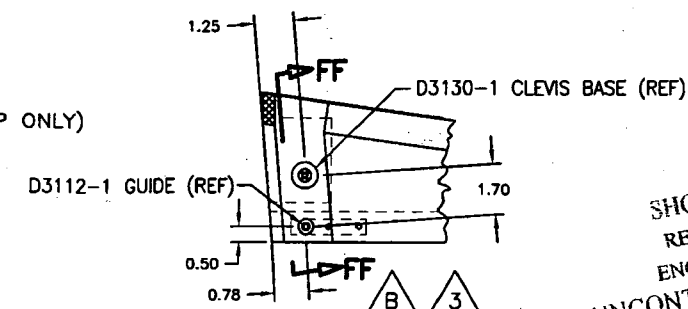


VIEW RR-RR



SECTION BB-BB

VIEW SHOWN WITH MECHANISM  
IN THE UNLOCKED POSITION  
FOR CLARITY



SECTION X-X (SHOWN)  
SECTION Y-Y (SIMILAR)

D3125-1 LEVER NOT SHOWN FOR CLARITY

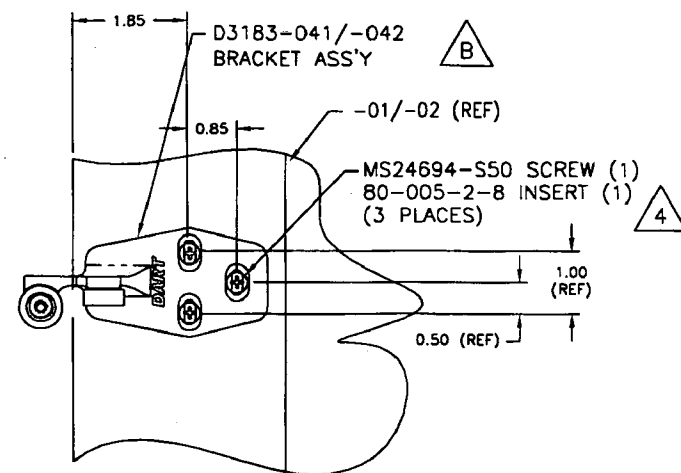
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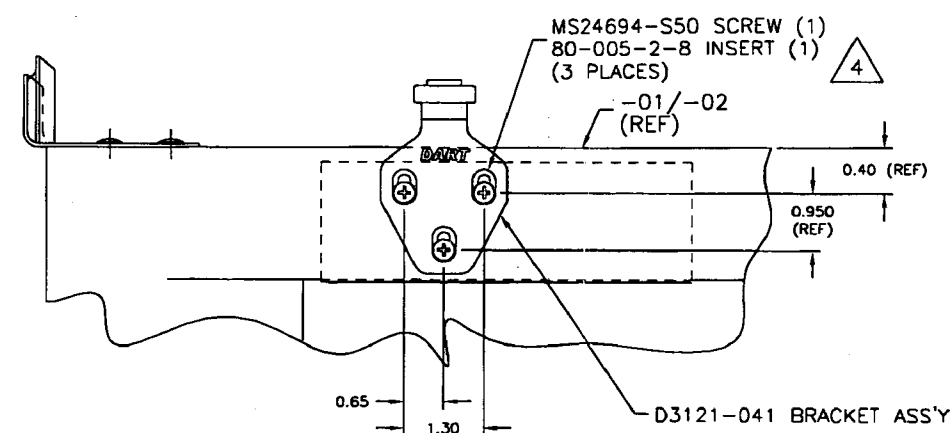
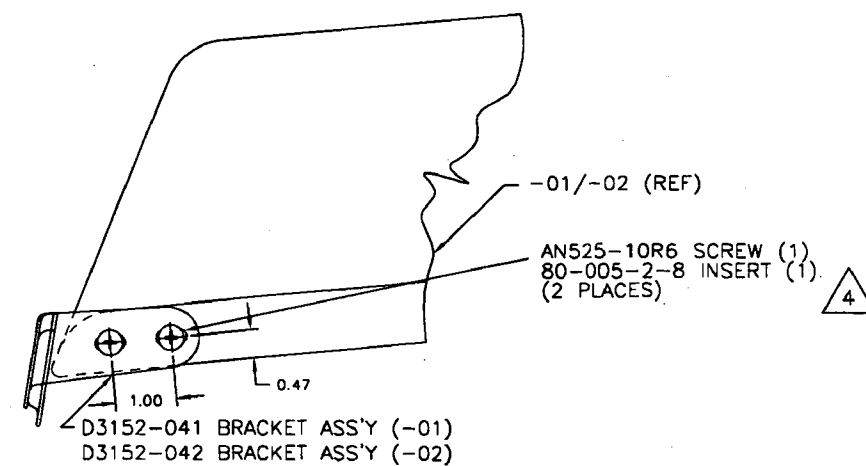
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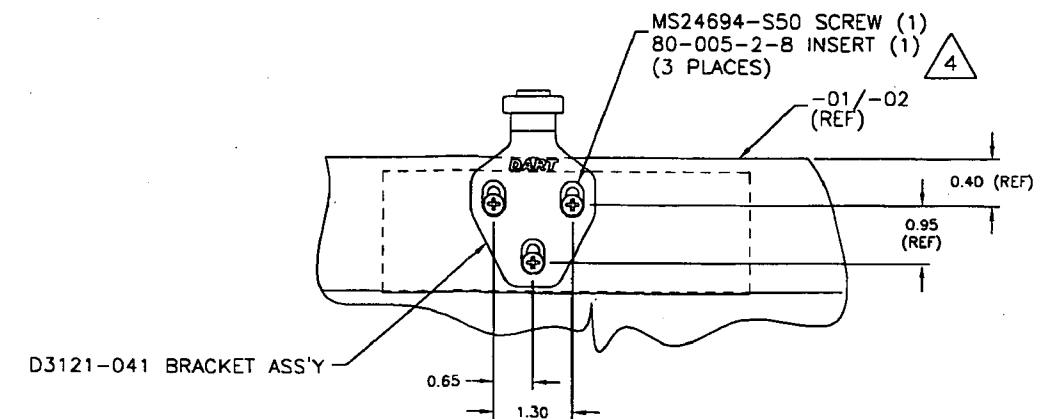
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DATE 05.11.23		TITLE DOOR ASSEMBLY	SCALE NTS



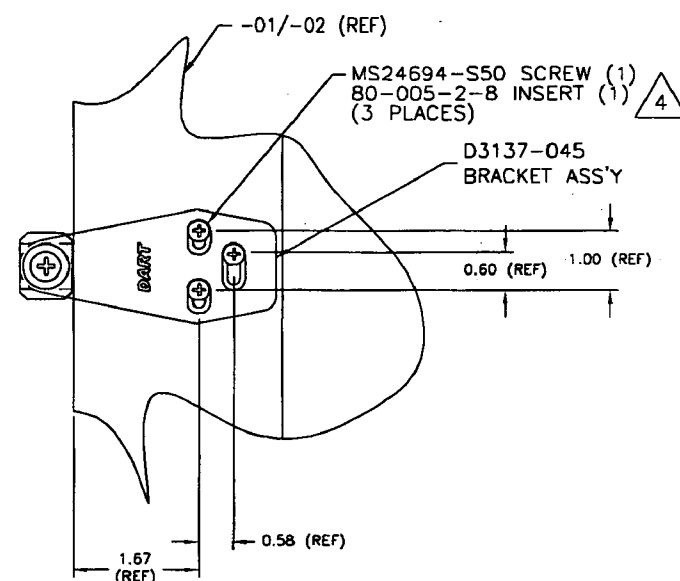
VIEW J



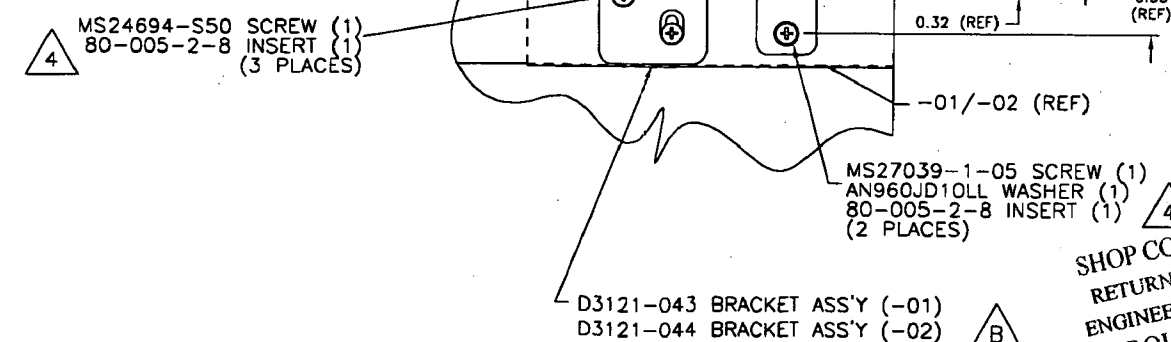
VIEW Q



VIEW L



VIEW H



VIEW M

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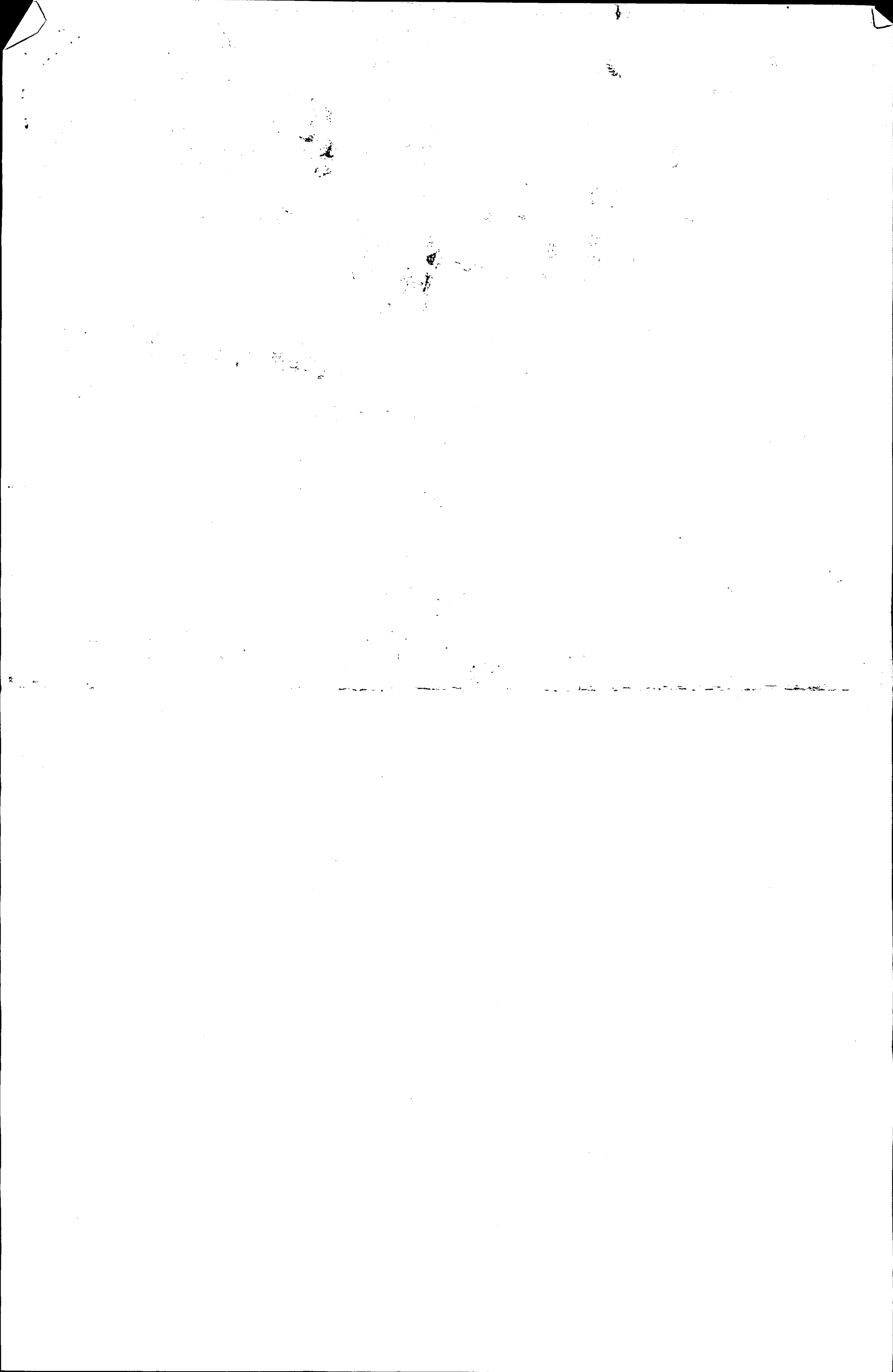
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TITLE DOOR ASSEMBLY	SCALE NTS





DELASTEK COMPOSITES INC.  
2699, 5ième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12639
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Point de départ		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #	
28/04/2008	08/06/2006	4699	C. Lavoie	PO00001429			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC135-0019	D3140-06 Door Right Non Assy ( Grosse ) Job: 42212			
1	0	1	DKC135-0020	D3140-08 Door Right Non Assy ( Petite ) Job: 42212			
1	0	1	DKC135-0017	D3140-05 Door Left Non Assy ( Grosse ) Job: 42210			
1	0	1	DKC135-0018	D3140-07 Door Left Non Assy ( Petite ) Job: 42210			

*Re 4/0/2*  
*Approved work order*

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:


Quality department


AQ-357



Date: Lundi, 2007-11-12 10:54:08  
 Utilisateur: Marc Dubé

## Feuille de Procédé

<b>Client</b> : DART Dart Aerospace Ltd.	<b>Nom Dessin</b> : DOOR	 DAC 135-0019 DKC 135-0020 17-01-07 J.S.
<b>Numéro Job</b> : 42212	<b>Numéro Article</b> : <del>DKC135-0010/-0011</del>	
<b>Numéro Soumission</b> : 1726	<b>Numéro Dessin</b> : D3140	
<b>Numéro B.A.</b> :	<b>Projet Numéro</b> : DKC135	
<b>Cette fois</b> : 2007-11-12 <b>No. B.V.</b> :	<b>Révision dessin</b> : F	
<b>Prsht Rev.</b> : NC	<b>Matériel</b> : Tissu Fibercote E-761/7788	
<b>Prem. fois</b> :	<b>Date Dûe</b> : 2007-10-11	<b>Qté:</b> 1 UdM: UNITE
<b>Job précédente</b> : 42211		

**Écrit par** :   
**Vérifié & Approuvé par** :  
**Commentaires** : N° de pièce Dart Aerospace: D3140-06/-08  
 N° de pièce Delastek Aeronautique: DKA359-0010/-0011  
 N° de pièce Delastek Composites: DKC135-0010/-0011

Process Sheet Rév.: 11 Changer la révision de dessin pour la Rév.:  
 F

## Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	OUTILLAGE	OUTILLAGE NÉCESSAIRE À LA FABRICATION



**Commentaire** Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
 OUTILLAGES NÉCESSAIRES À LA FABRICATION DE LA PIÈCE


Moule N° B30-23000-02T  
 Patron de découpe N° B30-23000-57T  
 Patron de découpe N° B30-23000-61T  
 Patron de découpe N° B30-23000-63T  
 Patron de découpe N° B30-23000-69T  
 Patron de découpe N° B30-23000-71T  
 Patron de découpe N° B30-23000-73T  
 Patron de découpe N° B30-23000-75T  
 Patron de découpe N° B30-23000-77T  
 Patron de découpe N° B30-23000-79T  
 Gabarit de taillage N° B30-23000-06T ( 2 pièce ) et N° B30-2300-04T  
 Forme de silicone N° B30-23000-08T

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------



**Commentaire** Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
 PRÉPARATION DU MOULE

Préparation du moule selon la section 5.0 de l'instruction de travail TEC-77

Quantité: 1 Date: 23-11-07 Sceau: 

Date: Lundi, 2007-11-12 10:54:08

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42212

Nom Dessin: DOOR  
Numéro Article: DKC135-0010/-0011

Numéro Job:



# Séq.: Machine ou Opération: Description :

3.0 AMB0211 PREPERG FIBERCOTE E761/7781 roul. 50"

Commentair Qty.: 12.3 VERGE(s)/Unit Total: 12.3 VERGE(s)  
PREPERG FIBERCOTE E761/7781 roul. 50"

N° de Lot: 1-6293-1

4.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs  
DÉCOUPAGE MATÉRIEL

Découpe du tissu pré-imprégné e-761 paquets de 10.5 pi². ( 7 paquets =24.5 Verges )

Quantité: 1 Date: 26/11/07 Sceau:



5.0 DRAPAGE 1 DRAPAGE DART



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs  
DRAPAGE DES PIECES

Faire le drapage de 3 plis de tissu pré-imprégné e-761 ( 4 Paquets ) selon la section 8.1.1 de l'instruction de travail N° TEC-77.

Quantité: 1 Date: 26/11/07 Sceau:



6.0 AC0409 Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total: 4.37 VERGE(s)  
Tissu à délaminer Release ply B

7.0 AC0407 Wrightlon 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total: 7.18 VERGE(s)  
Wrightlon 5200 Bleu P3

8.0 AC0408 Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total: 6.00 VERGE(s)  
Feutre de drainage N° Airweave N 10

9.0 AC0755 Sac à vide N° Strechlon 700

Commentair Qty.: 7.770 METRE CAR(s)/Unit Total: 7.770 METRE CAR(s)  
Sac à vide N° Strechlon 700

10.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 RL(s)/Unit Total: 2.0000 RL(s)  
Ruban à gommer jaune #: T/AT-200Y



Date: Lundi, 2007-11-12 10:54:08  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42212

Nom Dessin: DOOR  
Numéro Article: DKC135-0010/-0011

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

11.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
------	----------------	-----------------------



Commentaire Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs  
EFFECTUER LA POCHE A VIDE

Faire le montage cuisson selon la section 8.2.1 de l'instruction de travail N° TEC-77.

Quantité: 1

Date: 26/11/07

Sceau:



12.0	CUISSON 1	CUISSON PIÈCE DART
------	-----------	--------------------



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
CUISSON DES PIECES

Faire la cuisson selon la section 8.3.1 de l'instruction de travail N° TEC-77

Inscrire le N° de cuisson: 5741

Quantité: 1

Date: 26/11/07

Sceau:



13.0	DÉMOULAGE 1	DÉMOULAGE PIÈCE DART
------	-------------	----------------------



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
DÉMOULAGE DES PIECES

Retirez le montage cuisson et faire les retouches de la pièce, afin d'enlever les surplus de résines et les résidus de tissu à délaminer.

Quantité: 1

Date: 27-11-07

Sceau:



14.0	INSPECTION 3	INSPECTION PIÈCE DART
------	--------------	-----------------------



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
INSPECTION GÉNÉRALE

Inspection de la première coquille par le département de la qualité pour s'assurer qu'il n'y aie pas de réparation à faire avant la prochaine étape.

Quantité: 1

Date: 27-11-07

Sceau:



Date: Lundi, 2007-11-12 10:54:09

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42212

Nom Dessin: DOOR  
Numéro Article: DKC135-0010/-0011

Numéro Job:



# Séq.: Machine ou Opération: Description:

15.0 ACP0006 Rohacell 71S 1"thick 49.2" x 98.4" plain

Commentair Qty.: 2.00 UNITE(s)/Unit Total: 2.00 UNITE(s)  
Rohacell 71S 1"thick 49.2" x 98.4" plain

N° de Lot: 1-6290-1

1-5733-1

16.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 360.0000Min Total Run: 6.0000Hrs  
DÉCOUPAGE PRIMAIRE

Faire la découpe des pièces de mousse structurales ( Rohacell ) sur la scie à ruban selon la section 8.1.2  
de l'instruction de travail N° TEC-77.

Quantité: 1 Kit Date: 27-11-07 Sceau:



17.0 SÉCHAGE SÉCHAGE DU MATÉRIEL



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs  
SÉCHAGE DU MATÉRIEL

Faire le séchage du Rohacell selon les informations du manufacturier

Inscrire le N° de cuisson: 5742

Quantité: 1 Date: 27-11-07 Sceau:



18.0 AAC0560 FILM ADHESIF PF-7035-C

Commentair Qty.: 55 UNITE(s)/Unit Total: 55 UNITE(s)  
FILM ADHESIF PF-7035-C

N° de Lot: 1-6282-1



19.0 ACP0003 Core splice adhesive MA560.048

Commentair Qty.: 5 UNITE(s)/Unit Total: 5 UNITE(s)  
Core splice adhesive MA560.048

N° de Lot: 2-6292-1



20.0 AAC0563 EPOCAST 87269-A/B

Commentair Qty.: 0.25 KIT(s)/Unit Total: 0.25 KIT(s)

EPOCAST-87269-A/B ADTECH P-17

N° de Lot: 6420

27-11-07



Date: Lundi, 2007-11-12 10:54:09

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 42212

Numéro Article: DKC135-0010/-0011

Numéro Job:



# Séq.: Machine ou Opération: Description :

21.0 AAC0645 DOUBLER KIT D3140-6-8

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

DOUBLER KIT D3140-6-8

1-6408-2, 1-6309-8, 1-6313-2, 1-6421-1

N° de Lot: 1-6326-2, 1-6408-5, 1-6408-4, 1-6309-2

22.0 NETTOYAGE 3 NETTOYAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

NETTOYAGE GÉNÉRALE

Faire le nettoyage des doublers selon l'instruction générale N° I.G. # Lavage pièce aluminium traité alodine.

Quantité: 1 Kit Date: 28-11-07 Sceau:

Quantité: Date: Sceau:

23.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run: 3.0000Hrs

ASSEMBLAGE GÉNÉRALE DES PIÈCES

Mise en place des doublers et des pièces de mousse structurales selon la section 8.1.3 de l'instruction de travail N° TEC-77.

Quantité: 1 Date: 28-11-07 Sceau:



24.0 AC0409 Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total: 4.37 VERGE(s)

Tissu à délaminer Release ply B

25.0 AC0407 Wrightlon 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total: 7.18 VERGE(s)

Wrightlon 5200 Bleu P3

26.0 AC0408 Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total: 6.00 VERGE(s)

Feutre de drainage N° Airweave N 10

27.0 AC0755 Sac à vide N° Strechlon 700

Commentair Qty.: 7.770 METRE CAR(s)/Unit Total: 7.770 METRE CAR(s)

Sac à vide N° Strechlon 700

28.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 RL(s)/Unit Total: 2.0000 RL(s)

Ruban à gommer jaune #: T/AT-200Y



Feuille de Procédé

Client: DART	Dart Aerospace Ltd.	Nom Dessin: DOOR
Numéro Job: 42212		Numéro Article: DKC135-0010/-0011

Numéro Job: 




# Séq.:	Machine ou Opération:	Description :
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29.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
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Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs  
EFFECTUER LA POCHE A VIDE

Faire le montage cuisson selon la section 8.2.2 de l'instruction de travail N° TEC-77



Quantité: 1 Date: 28/11/07 Sceau:   

30.0	CUISSON 1	CUISSON PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
CUISSON DES PIECES

Faire la cuisson des pièces selon la section 8.3.2 de l'instruction de travail N° TEC-77




Quantité: 1 Date: 28/11/07 Sceau:  

31.0	DÉMOULAGE 1	DÉMOULAGE PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
DÉMOULAGE DES PIECES

Retirez le montage cuisson de sur la pièce, et enlever les résidus de ruban adhésif en teflon et les barres d'aluminium, Garder seulement la barre qui sépare les deux pièces.




Quantité: 1 Date: 29-11-07 Sceau:   

32.0	DÉCOUPE CORE	DÉCOUPE DU CORE DART
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Commentair Setup: 0.00Hrs/ Run: 210.0000Min Total Run : 3.5000Hrs  
USINAGE DES MOUSSE

Usinage des mousses sturcturales selon la section 8.1.4 de l'instruction de travail N° TEC-77

Quantité: 1 Date: 29-11-07 Sceau:   

33.0	INSPECTION 3	INSPECTION PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
INSPECTION GÉNÉRALE

Faire la vérification de l'usinage intérieur pour s'assurer que tout soit conforme au dessin avant la prochaine étape.

Date: - Lundi, 2007-11-12 10:54:09

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 42212

Numéro Article: DKC135-0010/-0011

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Quantité: 1 Date: 30-11-07 Sceau:



34.0 AMB0211 PREPERG FIBERCOTE E761/7781 roul. 50"

Commentair Qty.: 12.3 VERGE(s)/Unit Total: 12.3 VERGE(s)  
PREPERG FIBERCOTE E761/7781 roul. 50"

N° de Lot: 1-6293-1

35.0 DRAPAGE 1 DRAPAGE DART



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs  
DRAPAGE DES PIECES

Drapage de la coquille intérieur selon la section 8.1.5 de l'instruction de travail N° TEC-77

Quantité: 3-12-07 Date: 1 Sceau:



36.0 AC0409 Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total: 4.37 VERGE(s)  
Tissu à délaminer Release ply B

37.0 AC0407 Wrightlon 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total: 7.18 VERGE(s)  
Wrightlon 5200 Bleu P3

38.0 AC0408 Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total: 6.00 VERGE(s)  
Feutre de drainage N° Airweave N 10

39.0 AC0755 Sac à vide N° Strechlon 700

Commentair Qty.: 7.770 METRE CAR(s)/Unit Total: 7.770 METRE CAR(s)  
Sac à vide N° Strechlon 700

40.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 RL(s)/Unit Total: 2.0000 RL(s)  
Ruban à gommer jaune #: T/AT-200Y

41.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs  
EFFECTUER LA POCHE A VIDE

Faire le montage cuisson selon la section 8.2.3 de l'instruction de travail N° TEC-77.

Quantité: 1 Date: 3-12-07 Sceau:



Date: Lundi, 2007-11-12 10:54:09  
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART    Dart Aerospace Ltd.    Nom Dessin: DOOR  
Numéro Job: 42212    Numéro Article: DKC135-0010/-0011



Numéro Job: 


# Séq.:    Machine ou Opération:    Description :

42.0    CUISSON 1    CUISSON PIÈCE DART  
 

Commentair Setup: 0.00Hrs/ Run: 0.0000Min    Total Run : 0.0000Hrs  
CUISSON DES PIECES

Faire la cuisson de la pièce selon la sectino 8.3.3 de l'instruction de travail N° TEC-77.


Quantité: 1    Date: 3-12-07    Sceau:  

43.0    DÉMOULAGE 1    DÉMOULAGE PIÈCE DART  
 

Commentair Setup: 0.00Hrs/ Run: 60.0000Min    Total Run : 1.0000Hrs  
DÉMOULAGE DES PIECES

Retirez le montage cuisson, et faire de retouches sur la pièce afin d'enlever les surplus de résine et les résidus de tissu à délaminer.


Retirer la pièce du moule.


Quantité: 1    Date: 10-12-07    Sceau: 

44.0    TRIMAGE 3    TRIMAGE COMPOSITES DART  
 

Commentair Setup: 0.00Hrs/ Run: 60.0000Min    Total Run : 1.0000Hrs  
TRIMAGE DE FINITION

Faire le trimage de finition de la pièce selon la section 8.5 de l'instruction de travail N° TEC-77.

Quantité: 1    Date: 13-12-07    Sceau: 

45.0    AAC0671    Dupont Primer N° 1104S    77048 9.5. 18-01-08  
Commentair Qty.: 0.5000 GALLON(s)/Unit    Total : 0.5000 GALLON(s)  
Dupont Primer N° 1104S    N° de Lot: 1-6254-2 

46.0    AAC0670    Dupont Activator N° 7975S    77755  
Commentair Qty.: 1.0000 PINTE(s)/Unit    Total : 1.0000 PINTE(s)  
Dupont Activator N° 7975S    N° de Lot: 1-6473-1

47.0    AAC0672    Dupont Reducer N° 12375S  
Commentair Qty.: 0.1250 GALLON(s)/Unit    Total : 0.1250 GALLON(s)  
Dupont Reducer N° 12375S    N° de Lot: N/A

Date: Lundi, 2007-11-12 10:54:09  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42212

Nom Dessin: DOOR  
Numéro Article: DKC135-0010/0011

Numéro Job:



# Séq.: Machine ou Opération: Description :

48.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
PRÉPARATION DU MATÉRIEL

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

16-01-08



49.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
INSPECTION PIÈCE DART

Faire l'inspection par le département de la qualité "Tap test et inspection dimensionnel"

Date: 16-01-08 Sceau: QA-11 Initiales: H.S.

50.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
APPLICTION DE PRIMER

Appliquer une épaisse couche de primer partout sur les deux portes.

Quantité: 1 Date: 16-01-08 Sceau: DELASTEK COMPOSITES 61 D3140-06 MA

51.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
APPLICATION DE PRIMER

Appliquer une épaisse couche de primer partout sur les deux portes.

Quantité: 1 Date: 24-01-08 Sceau: DELASTEK COMPOSITES 61 D3140-08

52.0 FINITION 3 FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs  
FINITION GÉNÉRALE

Faire un sablage léger ( Grit 320-400 ) de toute les surfaces.


Quantité: 1 Date: 25-01-08 Sceau: DELASTEK COMPOSITES 61 4

Feuille de Procédé

Client: DART Dart Aerospace Ltd. Nom Dessin: DOOR  
Numéro Job: 42212 Numéro Article: DKC135-0010/-0011






Numéro Job: 




# Séq.: Machine ou Opération: Description :

53.0 AAC0671 Dupont Primer N° 1104S 77048  h.s. 18-01-08  
Commentaire Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s)  
Dupont Primer N° 1104S N° de Lot: 1-6254-2



54.0 AAC0670 Dupont Activator N° 7975S 7715  
Commentaire Qty.: 1.0000 PINTE(s)/Unit Total : 1.0000 PINTE(s)  
Dupont Activator N° 7975S N° de Lot: 1-6473-1




55.0 AAC0672 Dupont Reducer N° 12375S  
Commentaire Qty.: 0.1250 GALLON(s)/Unit Total : 0.1250 GALLON(s)  
Dupont Reducer N° 12375S N° de Lot: N/A

56.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART  
   
Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
PRÉPARATION DU MATÉRIEL JAN 2 5 2008  Nettoyage qty 1 JAN 2 5 2008   
Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant. 18-01-07 

57.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART  
   
Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
APPLICATION DE PRIMER JAN 2 5 2008   
Application d'une couche de primer de finition partout sur les deux portes.

Quantité: 1 Date: 18-01-07 Sceau:  D3140-06

58.0 IDENTIFICATION4 IDENTIFICATION PIÈCES DART  
   
Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
IDENTIFICATION DES PIÈCES

Identifier le numéro de la pièce, le numéro de job ainsi que la date de fabrication sur l'aluminium peinturé dans le dégagement des mécanisme de porte.  
Grosse porte : D3140-06   
Petite Porte: D3140-08 28-01-08   
Quantité: 1 Date: 18-01-08 Sceau: 





Feuille de Procédé

Client: DART	Dart Aerospace Ltd.	Nom Dessin: DOOR
Numéro Job: 42212		Numéro Article: DKC135-0010/-0011


Numéro Job:	
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# Séq.:	Machine ou Opération:	Description :
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59.0	INSPECTION 3	INSPECTION PIÈCE DART
		

Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
INSPECTION GÉNÉRALE

Inspection finale par le département de la qualité selon le dessin D3140.

Date: 28-01-08 Sceau:  Initiales: *G.S.*

60.0	EMBALLAGE 3	EMBALLAGE PIÈCE DART
		

Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
EMBALLAGE ET ENTREPOSAGE

Faire l'emballage selon la section 8.7 de l'instruction de travail N° TEC-77

Quantité: *2 pièces* Date: 28-01-08 Sceau: 